

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012906**Date Inspected:** 01-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Heavy Dock Jetty

1. This QA inspector, Baskar Govindarajan, performed Anchor bolt holes measurement at Tower trial assembly area along with Mr. Sandeep Kumar whose lot no. is B 227. These measurements was carried out in Skin A, B, C, D and E of inside East tower, Lift 1. This measurement has been carried out in between interior and exterior bearing stiffener and Anchor bolt holes. This distance observed to be approximately 4 mm in one of the bearing stiffener in Skin B. All the reading taken was handed over to SMR.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 255455 perform FCAW welding on, Exterior Bearing stiffener of inside North tower, Lift 1, Skin D, and weld joint identified as NSD1-SA 22 B/E-29. ZPMC CWI Identified as Mr. Zao chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F. (Photo attached)

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057244, 057180 perform FCAW welding on, Exterior Bearing stiffener of inside North tower, Lift 1, Skin C, and weld joint identified as NSD1-SA 17 F/G- 19, 25. ZPMC CWI Identified as Mr. Zao chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with

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WPS-B-T-2333-TC-P4-F.

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052075, 040367 perform FCAW welding on, Exterior Bearing stiffener of outside North tower, Lift 1, Skin C, and weld joint identified as NSD1-SA 17 F/G- 42, 62. ZPMC CWI Identified as Mr. Yu Qi guo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
